







Date: Tuesday, 07/04/2009 10:34:44 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 47015	
Estimate Number : 12811	
P.O. Number :	Part Number : D35921
This Issue : 07/04/2009 S.O. No. :	Drawing Number : D3592 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 46891	Material :
Written By :	Due Date : 22/04/2009 Qty: 20 Um: Each
Checked & Approved By : <u>JUD 09-04-07</u>	
Comment : Est Rev:A New Issue 07-03.26 ec	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M6061T6S125 6061-T6 .125 Sheet
	
Comment: Qty.: 0.1460 sf(s)/Unit Total : 2.9190 sf(s) 6061-T6 .125 Sheet Batch: <u>110062</u> <u>B 9-4-9</u> ***Grain must be Along 4.63*****	
2.0	WATER JET FLOW WATER JET
	
Comment: FLOW WATER JET 1-Cut as per Dwg D3592 *****ENSURE GRAIN IS AT 45 DEG AS PER DEO D3592-b-1***** Dwg Rev: <u>8</u> Prog Rev: <u>B</u> <u>B 9-4-9</u> 2-Deburr if necessary <u>B 9-4-9</u>	
3.0	QC2 INSPECT PARTS-AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 9-4-9</u>	
4.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK <u>509/04/13</u> <u>496</u> <u>Counter</u>	
5.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per Dwg D3592 using DT8949 <u>SB 09/04/15</u> <u>46</u>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:34:44 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47015

Part Number: D35921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



count

Comment: INSPECT WORK TO CURRENT STEP

5 09/04/16 (x46)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(46)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 2

9/4/16

50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/16 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 4705
Description: Bracket		Part Number: D3592-1
Inspection Dwg: D3592	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.132	✓			
Ø0.098	+0.004/-0.001	.101	✓			
0.506	+/-0.010	.507	✓			
0.256	+/-0.010	.256	✓			
0.756	+/-0.010	.757	✓			
3.256	+/-0.010	3.258	✓			
0.262	+/-0.010	.264	✓			
1.993	+/-0.010	1.993	✓			
3.341	+/-0.010	3.342	✓			
3.641	+/-0.010	3.648	✓			
3.897	+/-0.010	3.899	✓			
3.762	+/-0.010	3.770	✓			

Measured by: B
Date: 9-4-9

Audited by: S
Date: 09/04/03

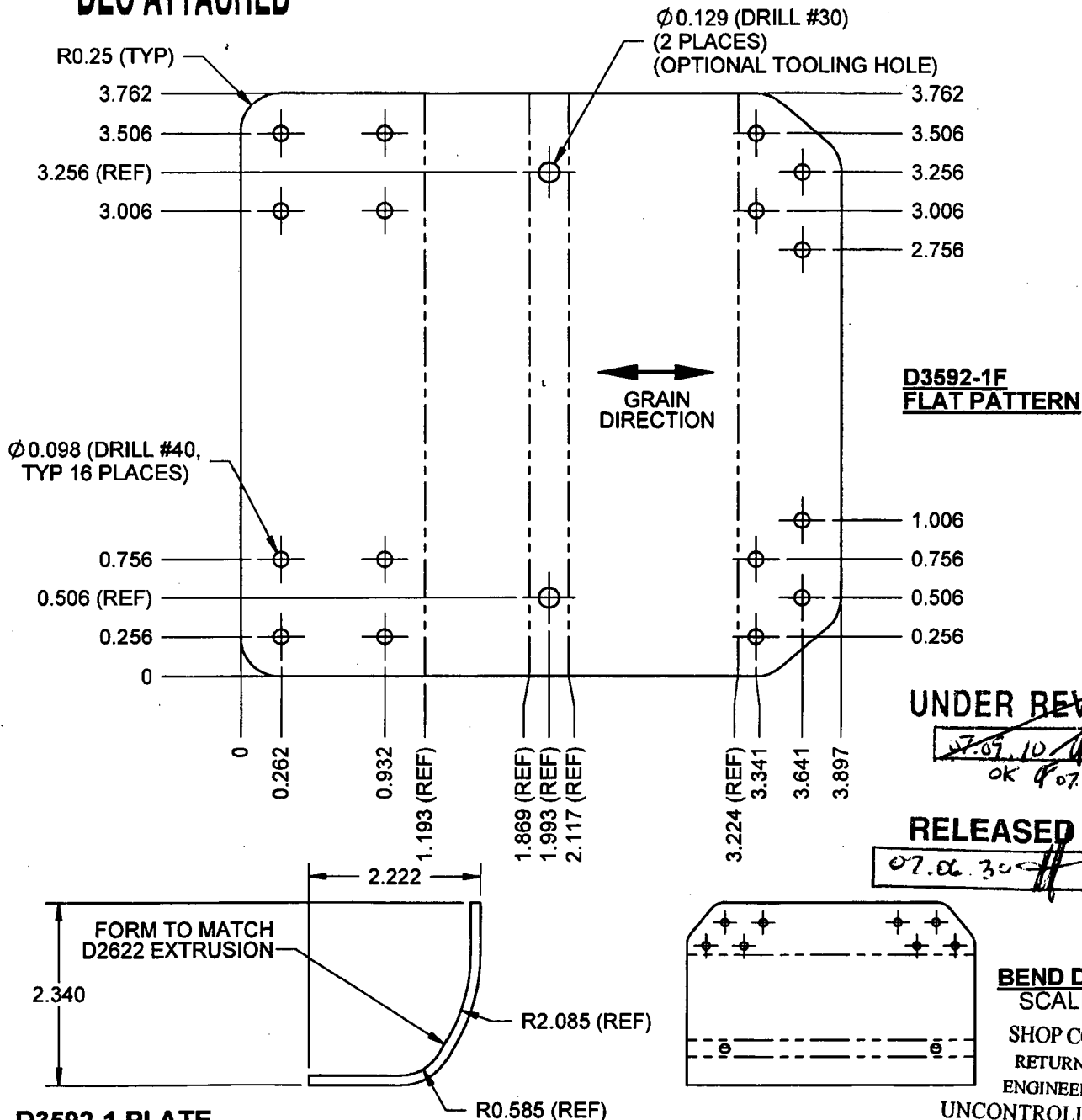
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	✓



DESIGN qp	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED qp	APPROVED [Signature]	DRAWING NO. D3592	REV. B SHEET 1 OF 1
DATE 07.05.31	TITLE PLATE SCALE 1:1		
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	

DEO ATTACHED



D3592-1 PLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

UNDER REVIEW

07.07.10
OK [Signature]

RELEASED

07.06.30 [Signature]

BEND DETAIL
SCALE 1:2

SHOP COPY
RETURN TO
ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 47065

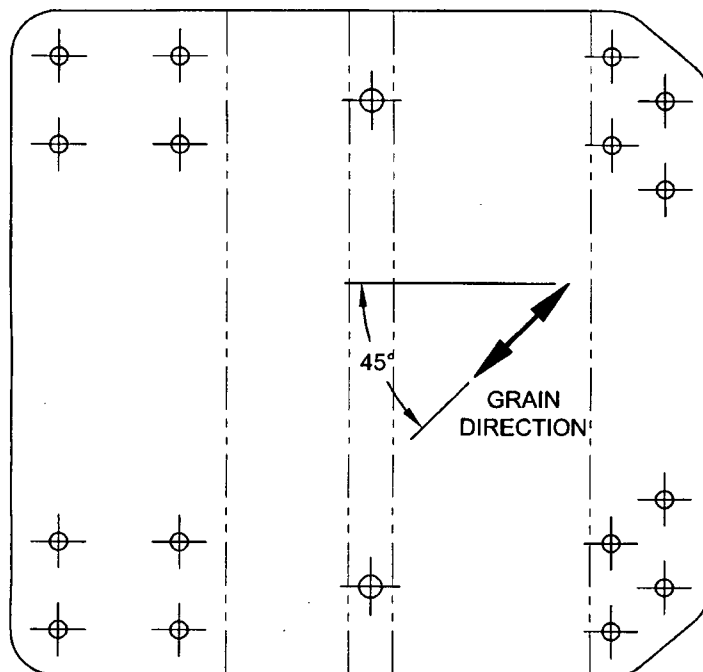
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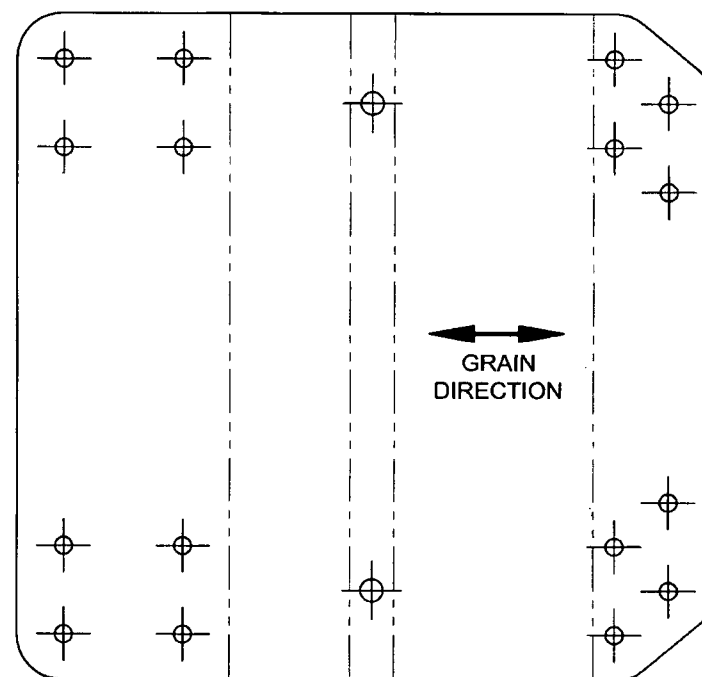
DRAWING NO. D3592	TITLE PLATE	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3592-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED b	MFG. APPR. AD	APPROVED MP		DE APPR. H		
DATE 08.09.11	DATE 08.09.11	DATE 08/09/11	DATE 08/09/11		DATE 08/09/11		

MODIFY GRAIN DIRECTION AS SHOWN BELOW TO PREVENT CRACKING WHEN WELDING AT ASSEMBLY (SEE CAR 08-026).

IS:



WAS:



ALL OTHER INFORMATION REMAINS UNCHANGED

RELEASED
08.09.17

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
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WORK ORDER
NO. 4705

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